

Date: Wednesday, 5/16/2007 8:13:09 AM
User: Kim Johnston

Process Sheet

21

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 32371	
Estimate Number : 12543	
P.O. Number : <i>N/A</i>	Part Number : D35381
This Issue : 5/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3538 REV.A
Prsht Rev. : NC	Project Number : 10254N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 31123	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/22/2007 Qty: 16 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev. A New Issue 06-10.03 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
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Comment: Qty.: 0.1995 f(s)/Unit Total : 3.1920 f(s)
6061_T6 Bar 1.250" x 1.250
Batch: *M105220*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 1.500" long

SD 07.05.20

16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1-Machine as per Folio FA651 and Dwg D3538
2-Deburr

gm / SD 07.05.20

16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

gm / SD 07.05.20

16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 07.05.20

16

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

HS

07.05.25

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/05/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 32371

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M 103141



(16)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M-L 07/05/29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/05/29 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/05/29 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/30

Job Completion



W 07-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

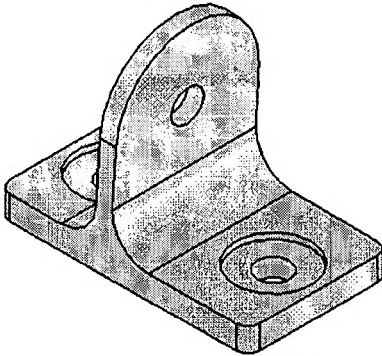
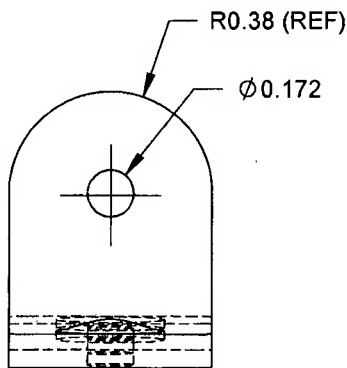
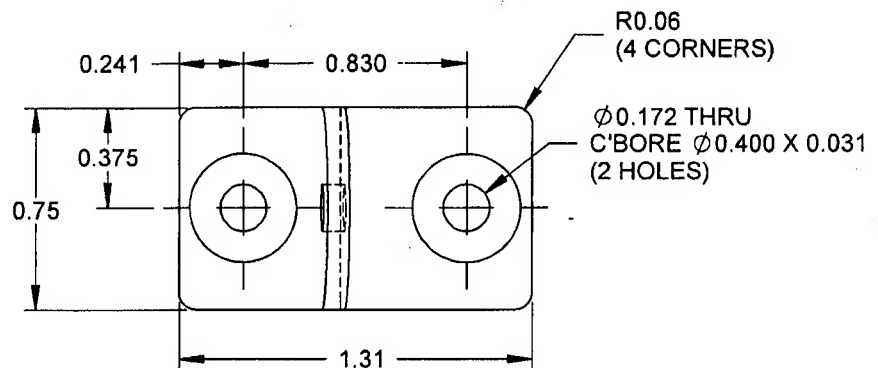
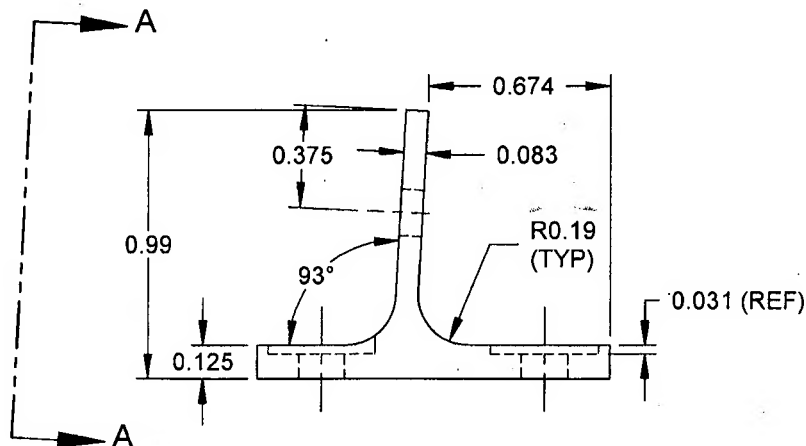
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
06.10.13 #**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

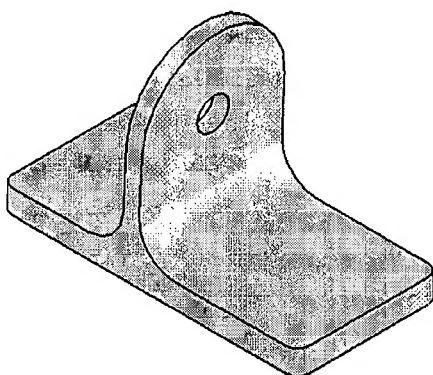
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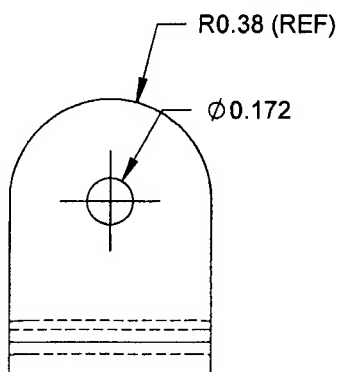
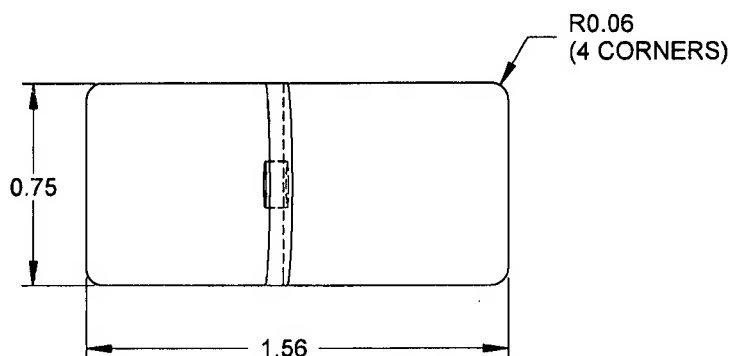
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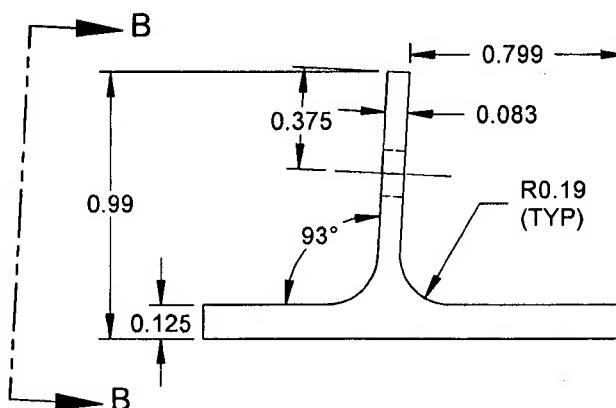
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1



RELEASED
06.10.13



AUXILIARY VIEW B



D3538-3 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061-T6)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order: 32371
Description: Hinge Bracket		Part Number: 3538-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.75	$\pm .030$.754	/			
.375	$\pm .010$.378	/			
.241	$\pm .010$.240	/			
.830	$\pm .010$.831	/			
$\phi .172$	$\begin{matrix} +.004 \\ -.001 \end{matrix}$	$\phi .174$	/			
$\phi .400 \times .031$	$\phi .400 \times .031$	✓	/			
1.31	$\pm .030$	1.314	/			
.375	$\pm .010$	0.375	—			
.99	$\pm .030$	0.991	—			
.125	$\pm .010$.126	/			
R.19	$\pm .030$	R.188	/			
.083	$\pm .010$.085	/			
93°	$\pm 1/2^\circ$	93°	/			
.674	$\pm .010$	0.672	—			
R.38	$\pm .030$	R0.375	—			
$\phi .172$	$\begin{matrix} +.004 \\ -.001 \end{matrix}$	$\phi .173$	—			

Measured by: <u>MR/SA</u>	Audited by: <u>SE</u>	Prototype Approval: <u>N/A</u>
Date: <u>07/05/22</u>	Date: <u>07.05.22</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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